



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2590	REV. B SHEET 1 OF 7
DATE 96:09:16		TITLE 204 SKIDTUBE ASSEMBLY SCALE	
B	96:12:02	AS MANUFACTURED	

RELEASED
97/01/20 DS

SUPERCEDED BY
98/09/17 Rev.C DS

Qty	Part Number	Description
1	D2500-1	OUTER TUBE
1	D2597	204 WEB
1	D2598	STIFFENER
1	D2575	AFT CAP
1	D2576	STEP
16	D2579	CROSS BOLT SPACER
2	AN3-4A	BOLT
38	AKS7-1032-130L*	INSERT
2	AN960JD10L	WASHER

*OR ALS7-1032-130L

DEO'S

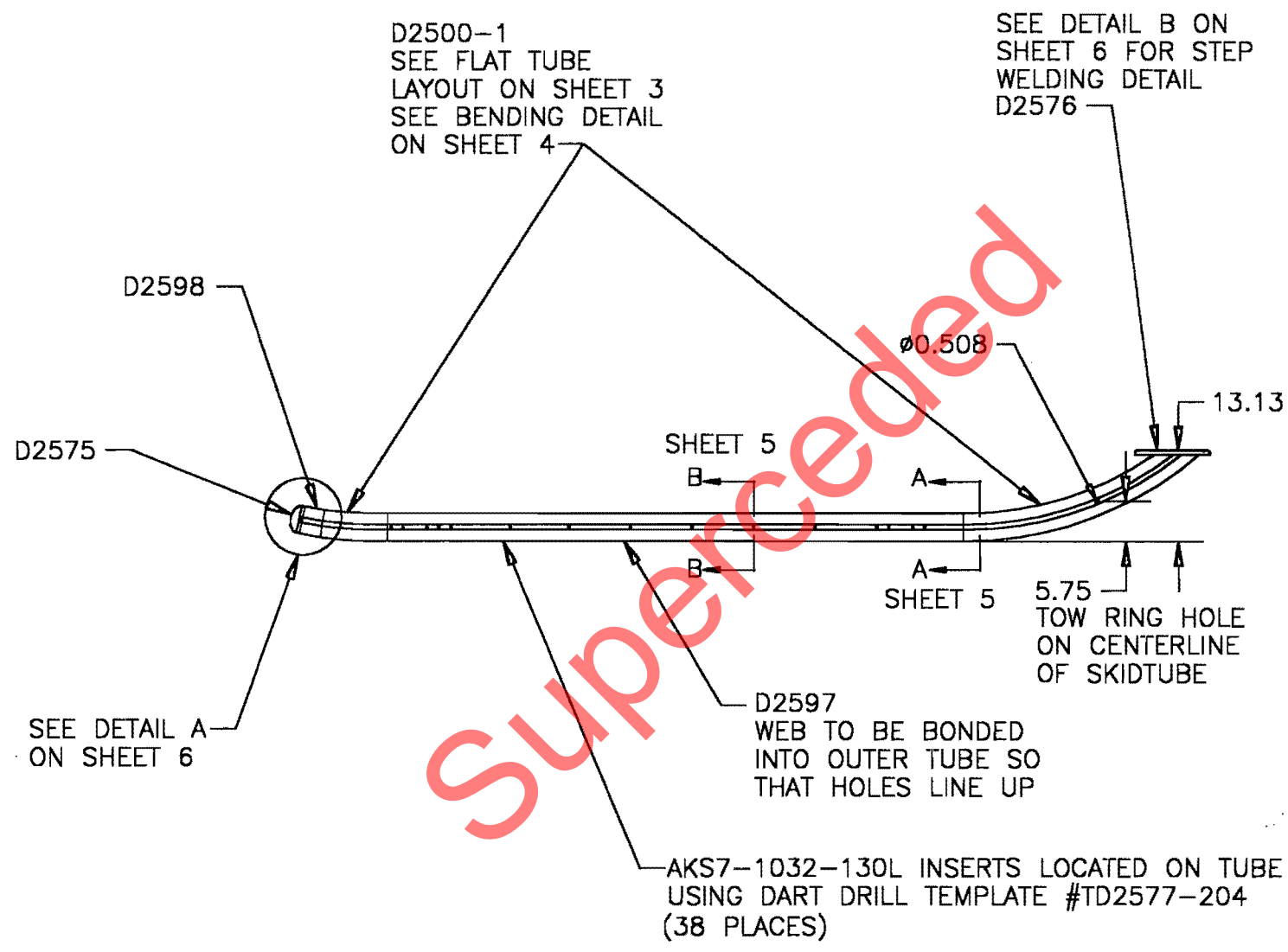
9088
97/10/23 DS

9094
97/10/29 DS

9097
97/12/14 DS

DART

DESIGN BY <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2590	REV. B
DATE 96:09:16		TITLE 204 SKIDTUBE ASSEMBLY	SHEET 2 OF 7
			SCALE 1:24

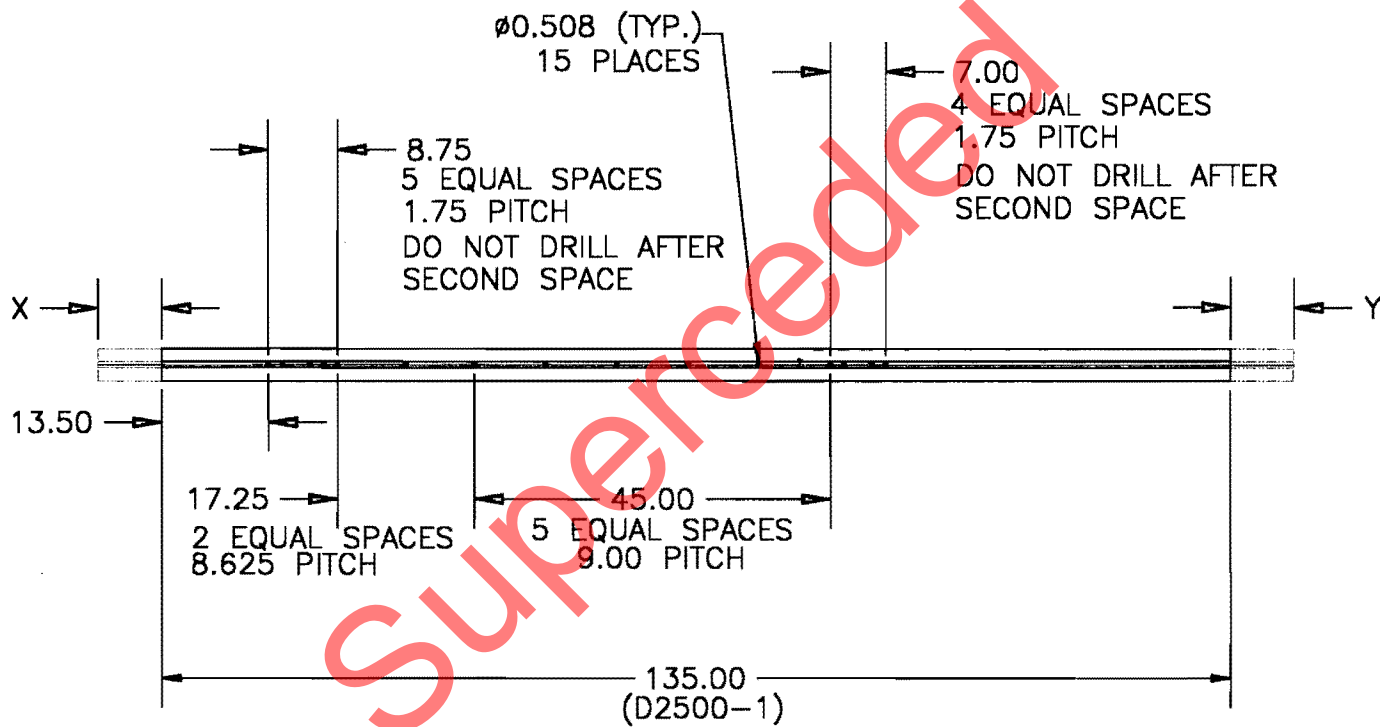


SEE SHEET 7 FOR FINISHING DETAIL



DESIGN <i>WJ</i>	DRAWN BY <i>WJ</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>WJ</i>	APPROVED <i>WJ</i>	DRAWING NO. D2590	REV. B
DATE 96:09:16	TITLE 204 SKIDTUBE ASSEMBLY	SHEET 3 OF 7	SCALE 1:24

INITIAL FLAT TUBE LAYOUT

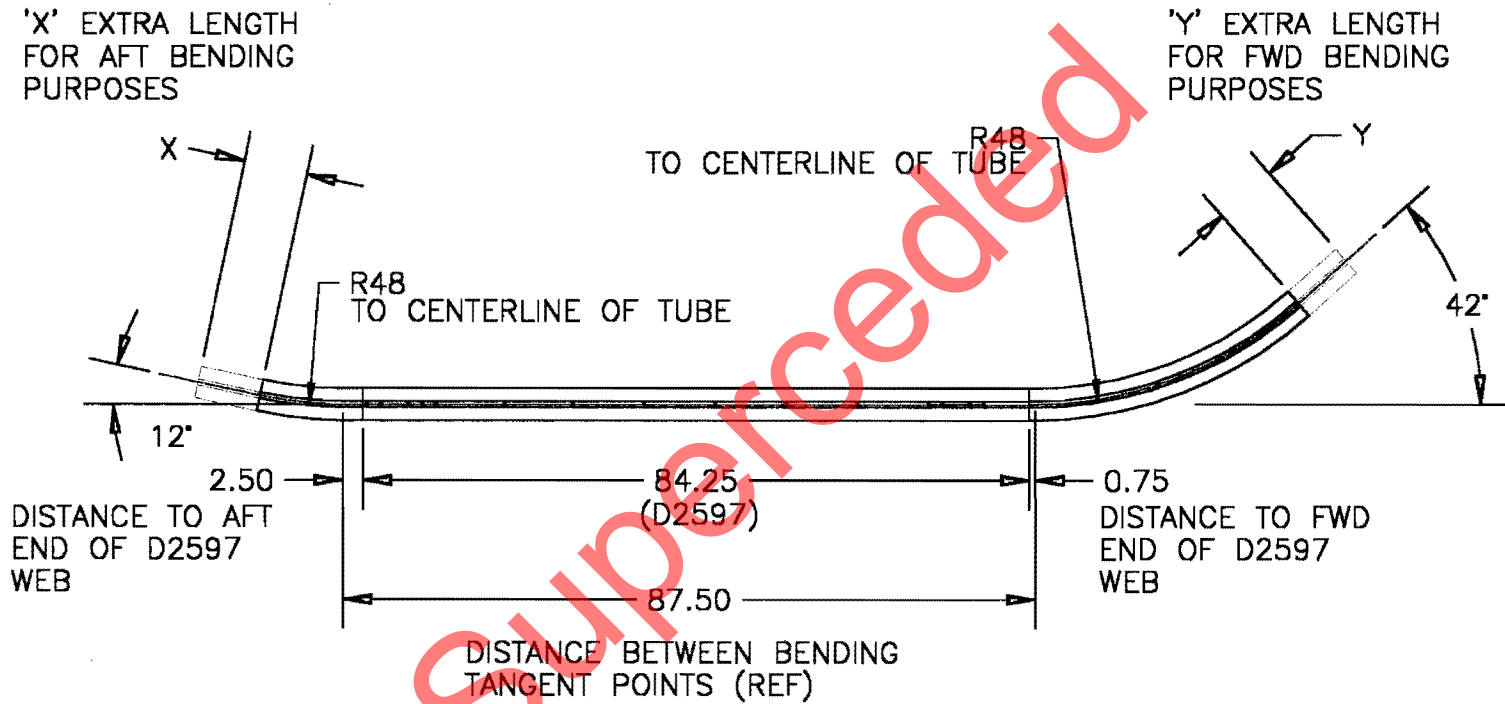


LENGTHS 'X' AND 'Y' ADDED TO D2500-1
LENGTH FOR BENDING PURPOSES

FINISH: ALODINE BEFORE INSERTING D2597 WEB

DART

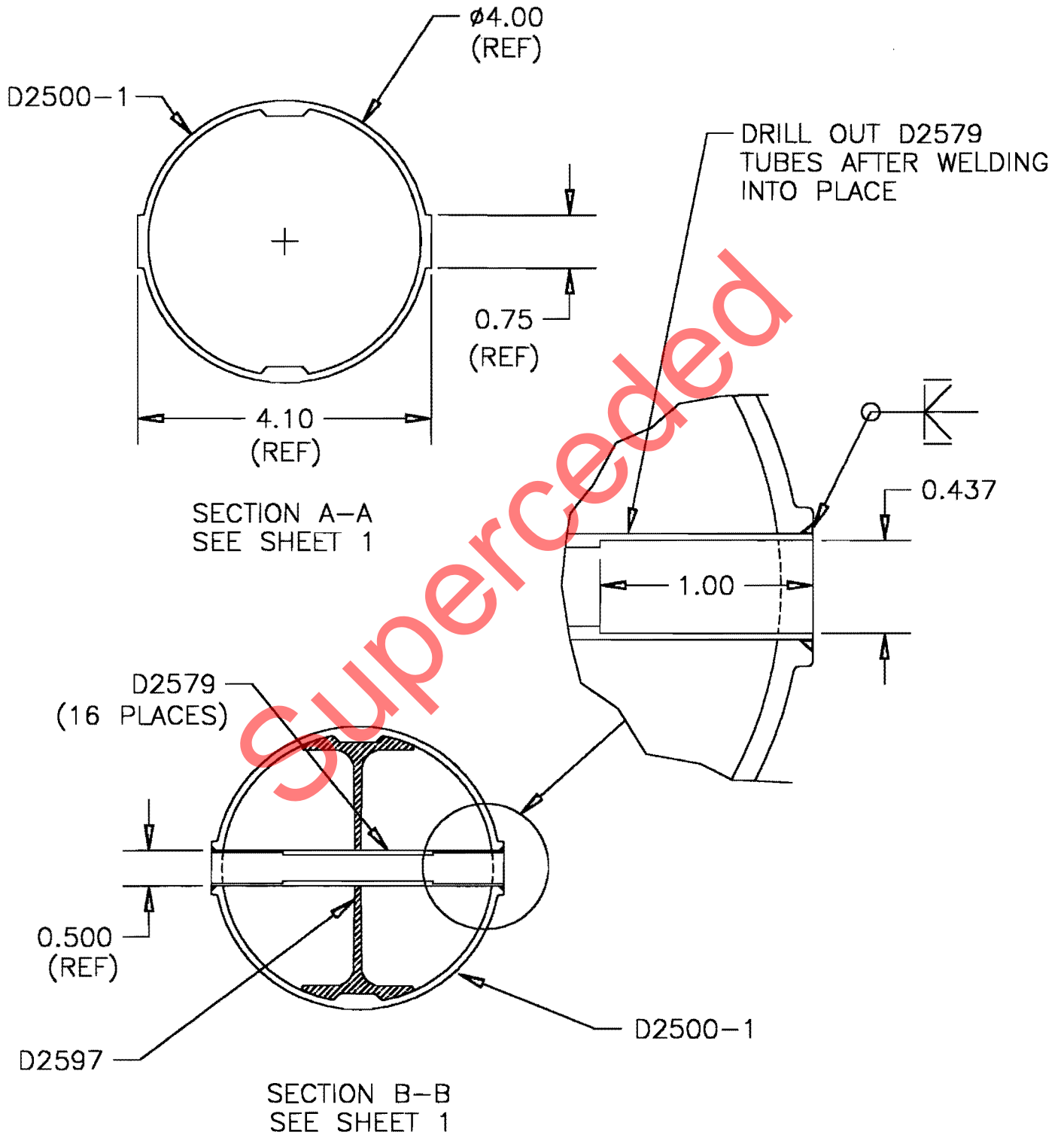
BENDING DETAIL



DESIGN 0108	DRAWN BY [Signature]	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. B
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2590	SHEET 4 OF 7
DATE 96:09:16	TITLE 204 SKIDTUBE ASSEMBLY	SCALE 1:24	



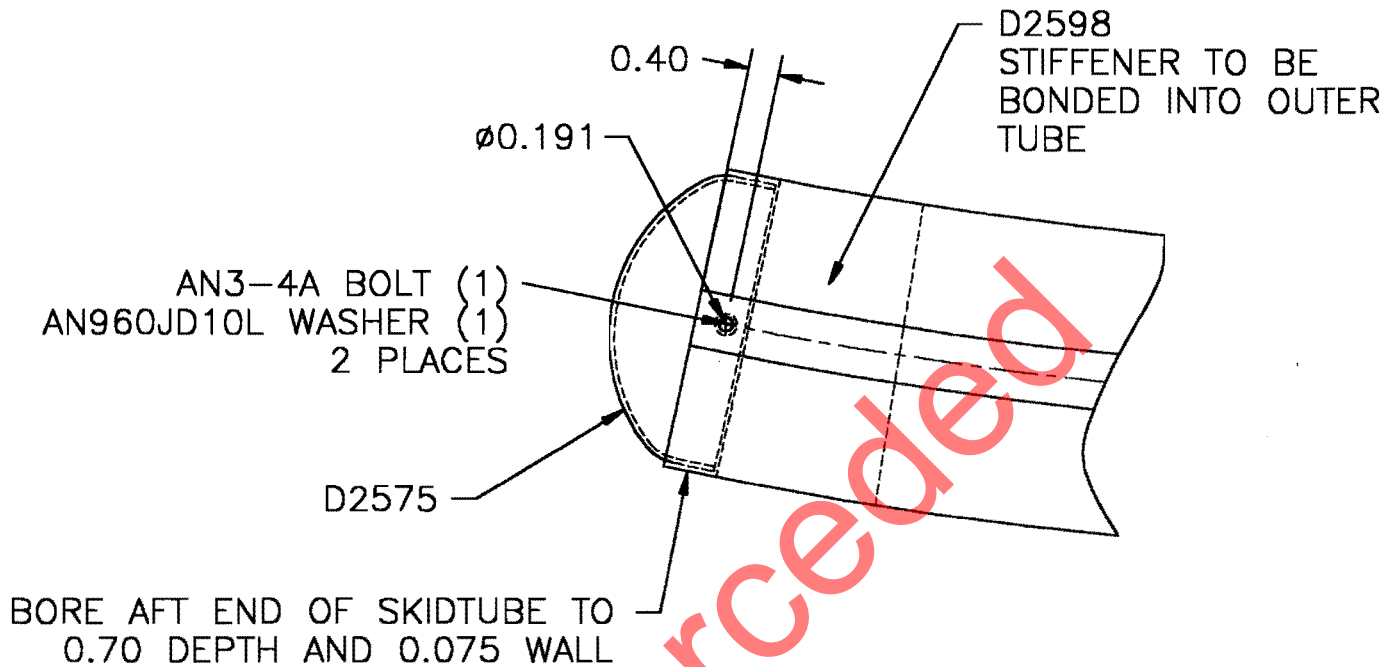
DESIGN DID	DRAWN BY DID	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED DID	DRAWING NO. D2590	REV. B SHEET 5 OF 7
DATE 96:09:16		TITLE 204 SKIDTUBE ASSEMBLY	SCALE 1:2



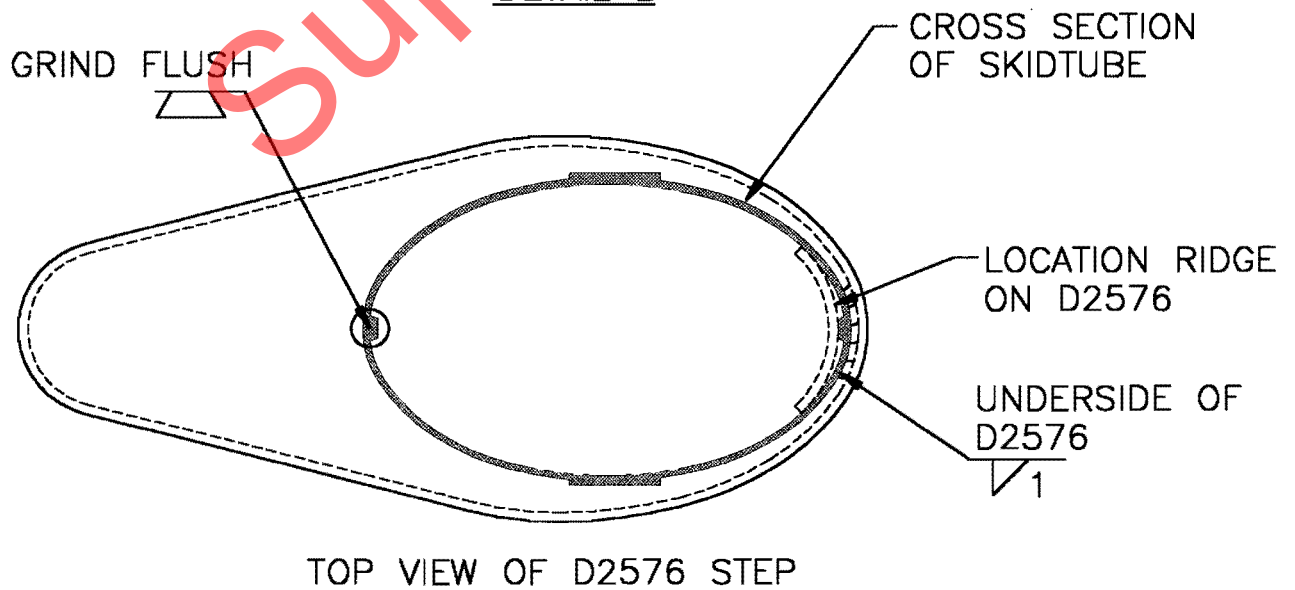


DESIGN <i>D108</i>	DRAWN BY <i>D108</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>D108</i>	DRAWING NO. D2590	REV. B SHEET 6 OF 7
DATE 96:09:16		TITLE 204 SKIDTUBE ASSEMBLY	SCALE

DETAIL A

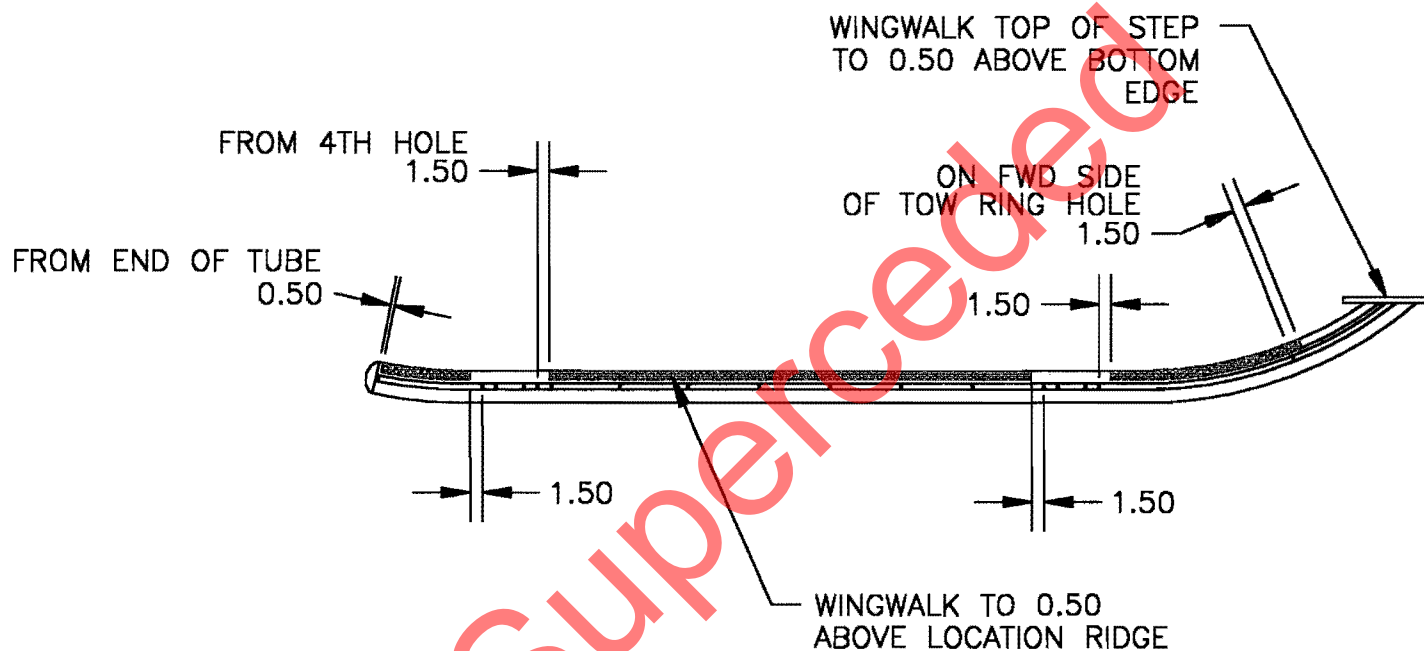


DETAIL B



DART

FINISHING DETAIL



FINISH: ALODINE, PRIME, PAINT HI-GLOSS WHITE, WINGWALK AS INDICATED
UNLESS OTHERWISE NOTED DISTANCES ARE FROM HOLE CENTRES

DESIGN <i>DM</i>	DRAWN BY <i>DM</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. B
CHECKED <i>BM</i>	APPROVED <i>DM</i>	DRAWING NO. D2590	SHEET 7 OF 7
DATE 96:09:16	TITLE 204 SKIDTUBE ASSEMBLY	SCALE 1:24	

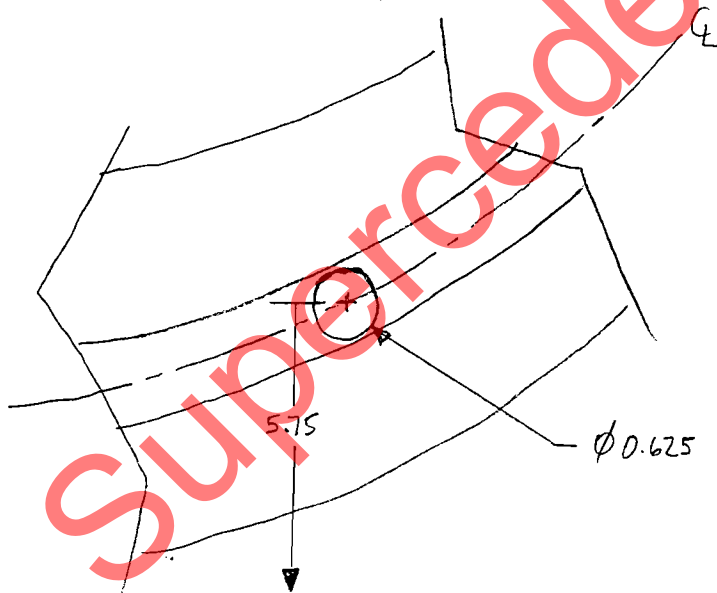


DESIGN DS	DRAWN BY DS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DEO 9094	REV. A SHEET 1 OF 1
DATE 97.10.22		TITLE TOW RING DRILLING CHANGE	SCALE NTS

DART ENGINEERING ORDER

TO AMEND DRAWINGS : D2580 REV. B
D2590 REV. B

RELEASED
97/10/29 DS



- DRILL TOW RING HOLE IN SAME LOCATION SPECIFIED BY DRAWINGS D2580 AND D2590.
- DRILL TO NEW DIAMETER OF 0.625
- DO NOT WELD IN D2579 CROSS BOLT SPACER

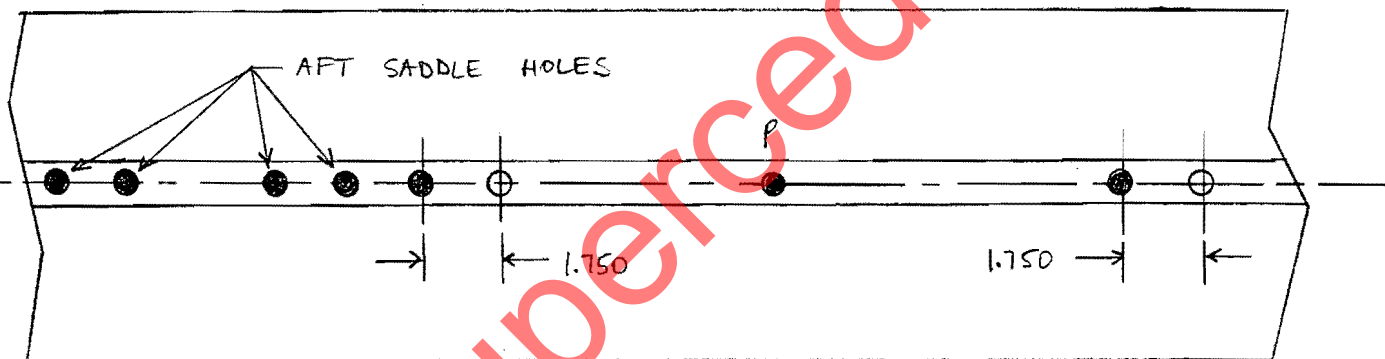


DESIGN DS	DRAWN BY DS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DEO 9097	REV. A SHEET 1 OF 1
DATE 97.12.14		TITLE 204/205 SKIDTUBE DRILLING CHANGE	SCALE NTS

DART ENGINEERING ORDER

TO AMEND DWGS: D2580 REV. B
D2590 REV. B
D2596 REV. B
D2597 REV. C

HOLE PATTERN FOR 204/205 SKIDTUBES SHOULD BE ADJUSTED
AS FOLLOWS:



NOTE: 1. ● = EXISTING HOLE
○ = NEW HOLE

2. WEB HOLES SHOULD BE DRILLED TO $\phi 0.63$ AS PER DWGS D2596 / D2597 (OPEN TO 0.500 IF ASSEMBLED TUBE IS BEING MODIFIED)
3. SKIDTUBE HOLES SHOULD BE DRILLED TO $\phi 0.500$ AND D2579 SPACERS SHOULD BE INSTALLED PER DWGS D2580 / D2590.
4. D2594 PLUGS SHOULD NOW BE INSTALLED IN HOLE MARKED 'P' ABOVE (TOTAL NUMBER OF PLUGS INCREASED FROM 14 TO 16)

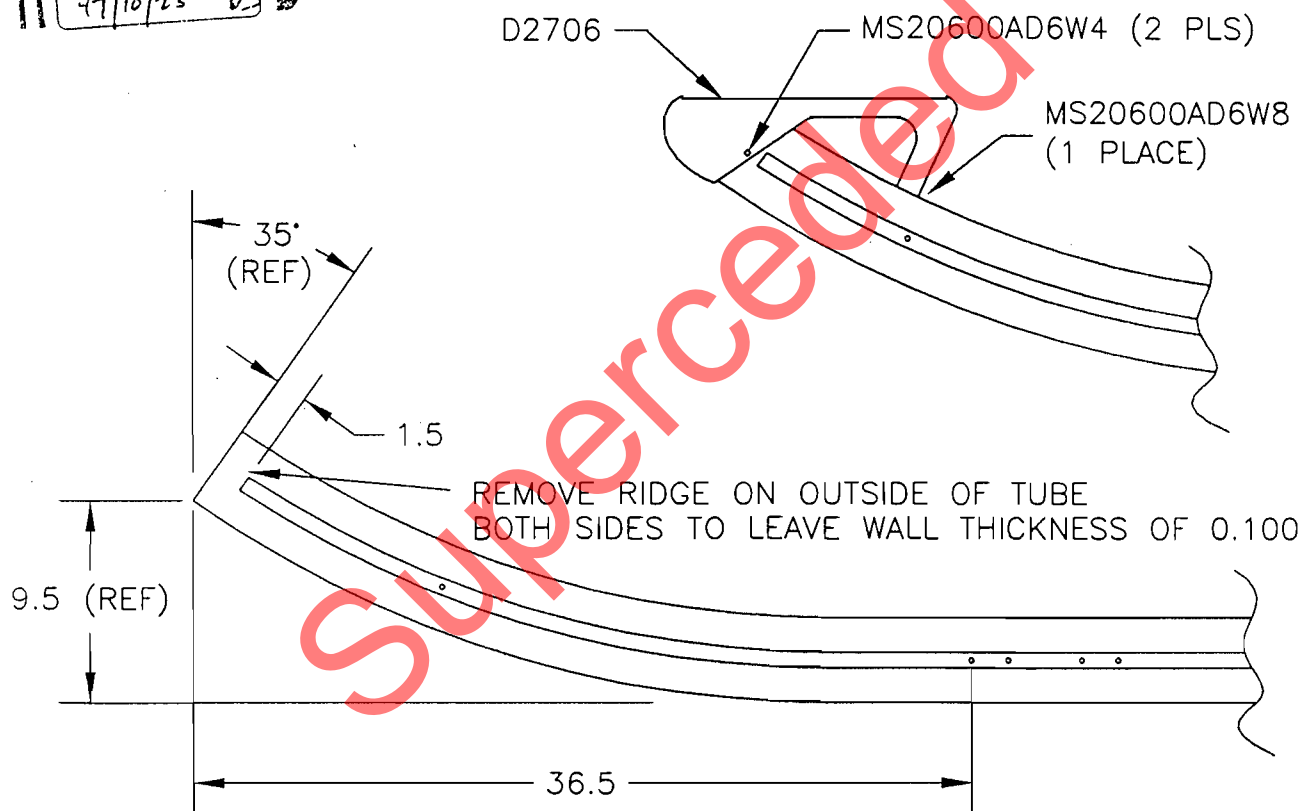


DESIGN <i>may</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>may</i>	APPROVED <i>KE</i>	DRAWING NO. DEO 9088	REV. A SHEET 1 OF 1
DATE 97.10.15		TITLE 204 SKIDTUBE STEP CHANGE	SCALE NTS
A	97.10.15	NEW ISSUE	

DART ENGINEERING ORDER

TO AMEND DART DRAWINGS D2590 REV B

RELEASED
47/10/23 DS



1. CUT TUBE TO DIMENSIONS SHOWN AND DE-BURR
2. REMOVE RIDGE ON OUTSIDE OF TUBE
3. LOCATE D2706 STEP
4. TRANSFER DRILL $\phi 0.191$ TO SKIDTUBE (3 PLACES) AND REMOVE SWarf
5. INSTALL MS20600AD6W4 (OR CR9163-6-4) RIVETS ON SIDES (2 PLACES)
6. INSTALL MS20600AD6W8 (OR CR9163-6-8) RIVETS ON TOP (1 PLACE)
7. SEAL EDGE OF D2706 STEP WITH SIKAFLEX-241 (OR EQUIVALENT) SEALANT PER MANUFACTURER'S SPECIFICATION